

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	206 L WEB
Job Number	:	33216.			
Estimate Number	:	10722			
P.O. Number	:	N/A	Part Number	:	D26547
This Issue	:	6/27/2007	S.O. No.	:	N/A
Prsht Rev.	:	NC	Drawing Number	:	D2654 REV E1
First Issue	:	N/A	Project Number	:	N/A
Previous Run	:	32578	Type	:	LANDING GEAR
			Drawing Revision	:	E1
			Material	:	N/A
Written By	:	[Signature]	Due Date	:	7/15/2007
Checked & Approved By	:	[Signature] 07.06.28			
Comment	:	Est Rev:D 99.02.04 Fixed typo, Changed procedure DM			
		Est Rev:e 06.04.05 Added level21 EC			

Qty: 8 Um: Each

(b) (5) DPP, (b) (7)(C), (b) (7)(D)

1.0	D26007125	Extrusion 'I Beam' thick
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty	Part Number	Description	Batch
1	D2600-7- 125140	Web	1321966

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-7 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

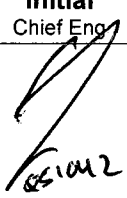
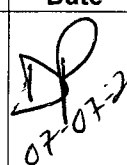
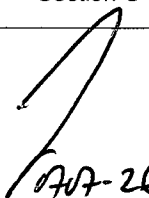
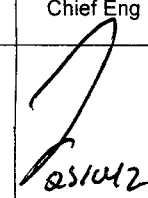
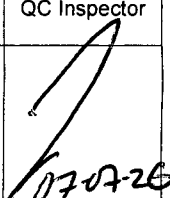
40	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: W Date: 07/07/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/26	2.0	The $\phi 0.75$ was oversized to 0.81 due to the uni-bit getting stuck in the hole. R.C. human error.		Acceptable. Ensure not to let the uni-bit go straight through. Per B-mail	 07/07/26	 07/07/26	 07/07/26	 07/07/26

NOTE: Date & initial all entries

Date: Wednesday, 6/27/2007 1:08:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L WEB

Job Number: 33216

Part Number: D26547

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION.



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 7-7-26

(8)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 46

DP 7-7-26

(8)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DP 7-7-27

(8)

Job Completion



u 7-7-27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

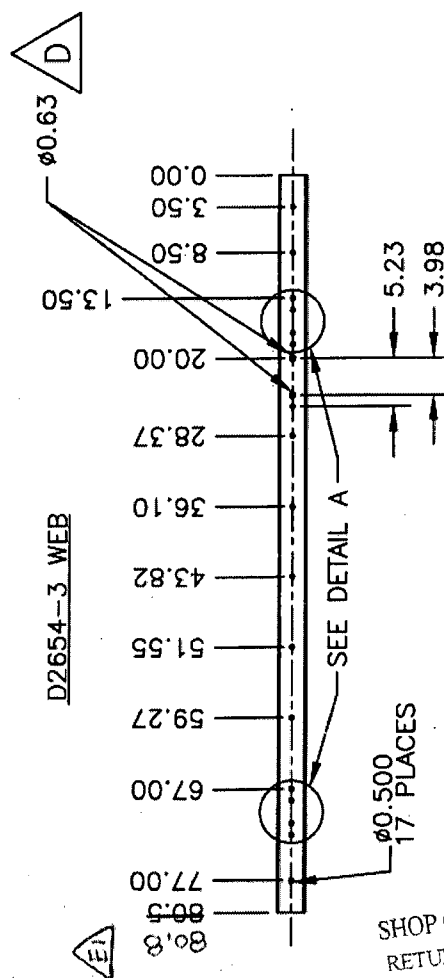
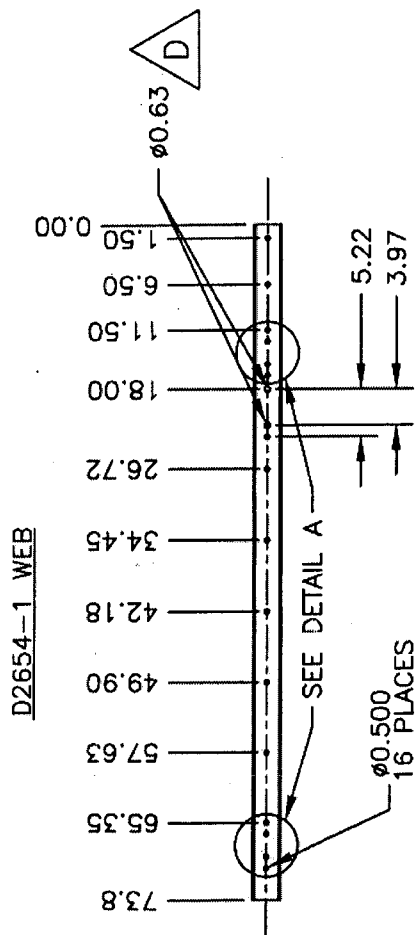
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Action Description	Sign & Date			

NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. E
				D2654	SHEET 1 OF 2
DATE			TITLE		
04.05.26			WEB		
			SCALE		
			1:20		
A	97.03.25		NEW ISSUE		
B	97.06.26		ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29		CHANGED HOLE PATTERN		
D	98.01.15		GHW HOLES CHANGED TO Ø0.63		
E	04.05.26		CHANGE LENGTHS, REFORMAT		
E1	CP	04.08.24	PER TOOLING; Ø0.8 WAS Ø0.5		

RELEASED
04.06.22

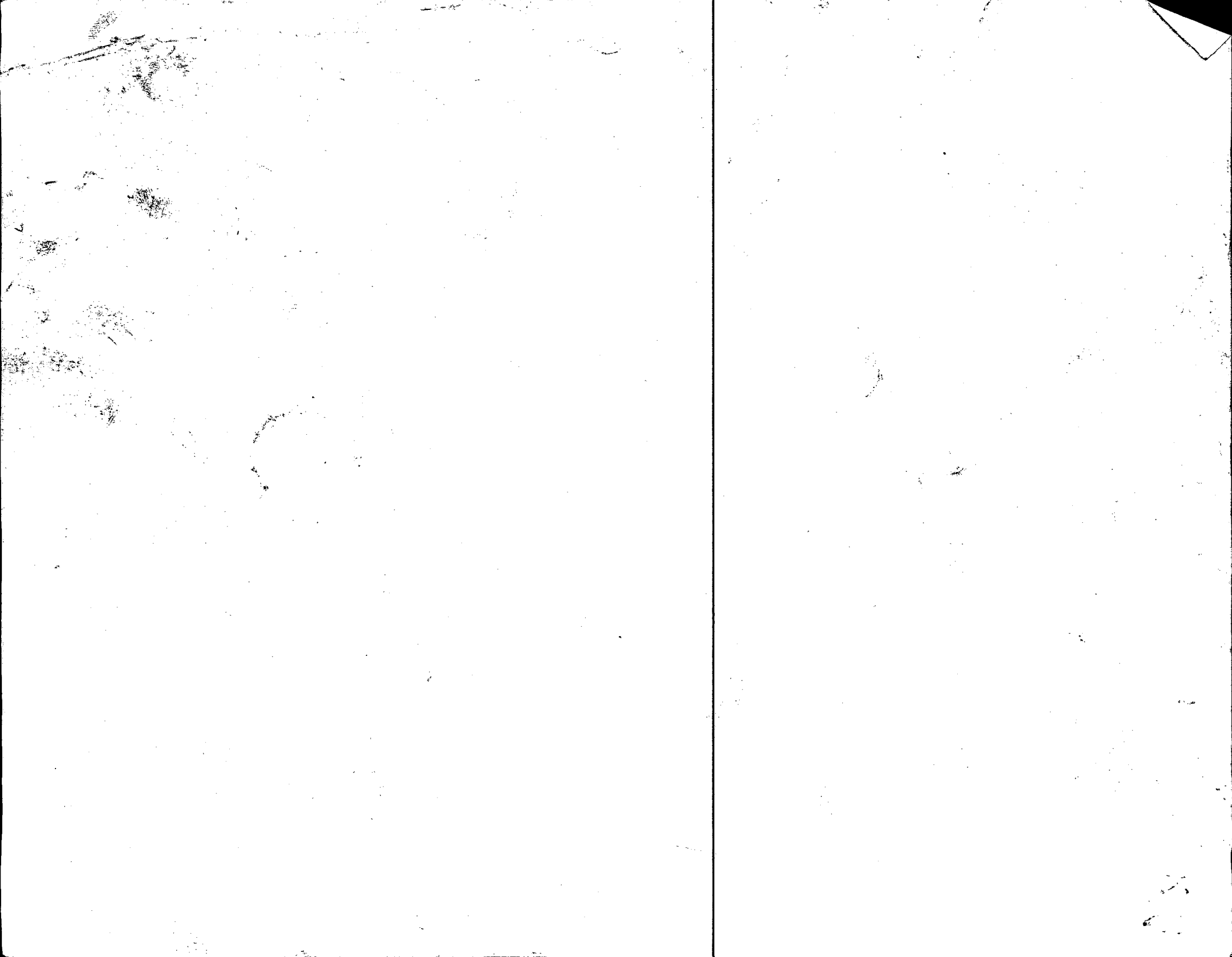


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WORK ORDER
NO. 33216

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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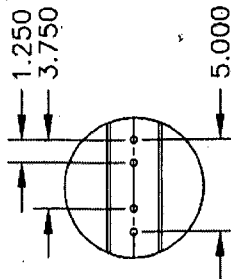




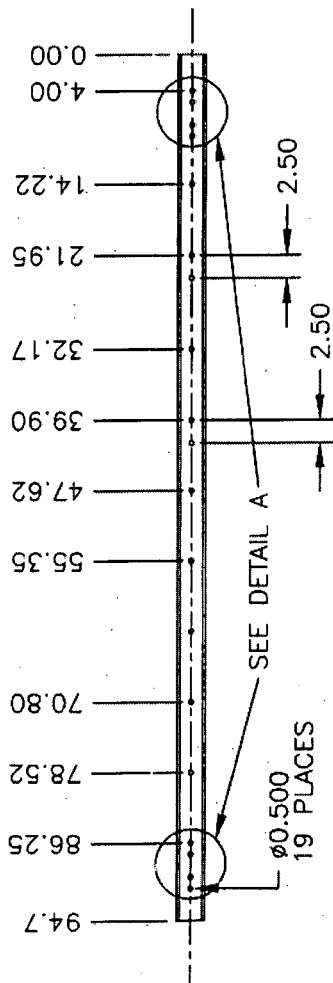
DESIGN UP	DRAWN BY UP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26	TITLE WEB		SCALE 1:20

RELEASED
04.06.22

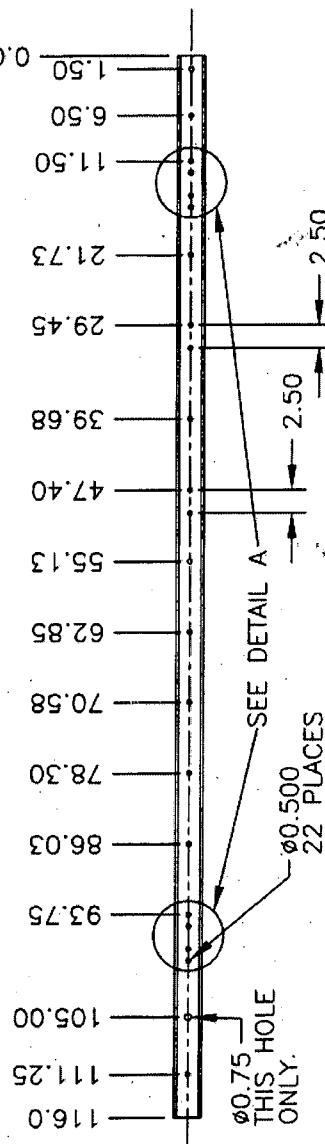
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Jason Murdoch

From: David Shepherd [dshepherd@dartaero.com]
Sent: Thursday, July 26, 2007 10:25 PM
To: 'Jason Murdoch'
Cc: 'Mike Petsche'
Subject: RE: NCR D2654 B33216

Acceptable deviation.

David

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: Thursday, July 26, 2007 11:07 AM
To: 'Mike Petsche'
Cc: 'David Shepherd'
Subject: NCR D2654 B33216

Good day Mike, the 0.75" hole on the -7 was slightly over sized due to the uni-bit getting stuck in the hole. The finished hole size on this 1 web at this location is 0.810". This is only a pass for a tow ring to be installed, therefore I think it will be fine as is. Is this acceptable?

jmurdoch@dartaero.com
Q.C. COORDINATOR

No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.5.476 / Virus Database: 269.10.14/912 - Release Date: 7/22/2007 7:02 PM

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7/30/2007